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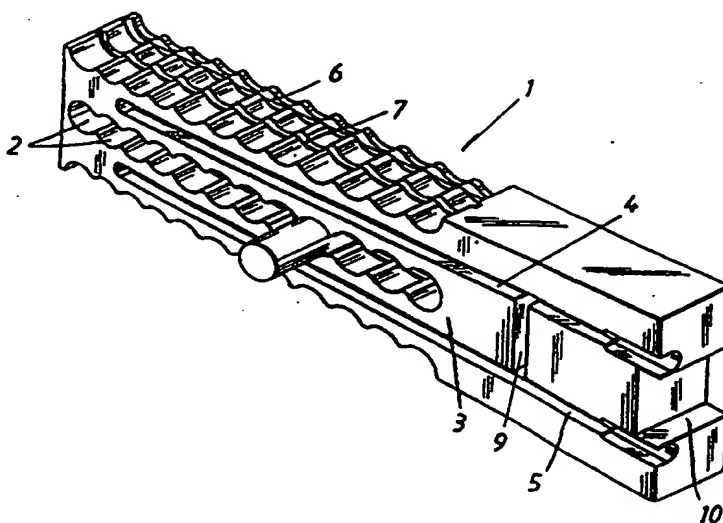
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(54) Title: END PLATE



(57) Abstract

An end plate (1, 11) for a stator (31) wound with cable in a rotating electric machine, the plate (1, 11) being provided with axially running winding slots (2) corresponding to the stator (31) and axially running apertures (19, 21, 22, 26) for cooling tubes corresponding to the stator (31), and that the plate (1, 11) is provided with at least one bending member (20, 23, 27) pre-shaped in the plate (1, 11) for cooling tubes (33) insertable into the cooling-tube apertures (19, 21, 22, 26) and also a procedure for supporting and protecting a cooling tube in a first axially running aperture at its exit from a stator in a rotating electric machine, whereby an end plate provided with bending members is applied at the end of the stator, the cooling tube being bent around the bending member before continuing, either by being fitted in a second axially running aperture in the stator or for extension out of the stator.

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END PLATE

TECHNICAL FIELD:

The present invention relates to rotating electric machines
5 such as synchronous machines, as well as dual-fed machines,
applications in asynchronous static current converter
cascades, outerpole machines and synchronous flow machines,
and also alternating current machines intended in the first
place as generators in a power station for generating
10 electric power. The invention relates particularly to the
stator of such machines concerning an embodiment for cooling
stator teeth and thus indirectly also to the insulated
electric conductors constituting the stator winding.

15 BACKGROUND ART:

Similar machines have conventionally been designed for
voltages in the range 6-30 kV, and 30 kV has normally been
considered to be an upper limit. This generally means that a
generator must be connected to the power network via a
20 transformer which steps up the voltage to the level of the
power network, i.e. in the range of approximately 130-400 kV.
The machine is intended for use with high voltages. High
voltages shall be understood here to mean electric voltages in
excess of 10 kV. A typical operating range for a device
25 according to the invention may be voltages from 36 kV up to
800 kV. In the second place the invention is intended for use
in the stated technical area with voltages below 36 kV.

Two different systems exist for air cooling in conventional
30 cooling: Radial cooling where the air passes the rotor
through the hub and radial ducts in the rotor, and axial
cooling where the air is blow into pole gaps by axial fans.
The stator is then divided into radial air ducts by means of
(usually straight) spacers which are welded in place. In view
35 of the poor thermal conductivity axially through the stator
laminations the air ducts must be frequently repeated. The
drawback of air cooling is that the ventilation losses are
often considerable and that the stator must be made longer to
accommodate the ventilation ducts. The ventilation ducts may

also cause a weaker mechanical structure, particularly in the case of the high-voltage generators with long teeth under discussion here.

5 Axial water cooling by means of cooling tubes in the stator yoke is well known. Electrically insulated metal tubes have then necessarily been used so as not to short-circuit the laminations of the stator. The drawback is that if the insulation is damaged the generator may be destroyed by the
10 induced currents then appearing. It is also expensive to weld or bend the tubes at the joins. Another drawback is that eddy currents are induced in metal tubes in a time-varying magnetic flow, resulting in certain power losses when they are used in an electric machine.

15

A conductor is known through US 5 036 165, in which the insulation is provided with an inner and an outer layer of semiconducting pyrolyzed glassfiber. It is also known to provide conductors in a dynamo-electric machine with such an
20 insulation, as described in US 5 066 881 for instance, where a semiconducting pyrolyzed glassfiber layer is in contact with the two parallel rods forming the conductor, and the insulation in the stator slots is surrounded by an outer layer of semiconducting pyrolyzed glassfiber. The pyrolyzed
25 glassfiber material is described as suitable since it retains its resistivity even after the impregnation treatment.

OBJECT OF THE INVENTION:

By using high-voltage insulated electric conductors, in the
30 following termed high-voltage cables, with solid insulation similar to that used in cables for transmitting electric power in the stator winding (e.g. XLPE cables) the voltage of the machine can be increased to such levels that it can be connected directly to the power network without an
35 intermediate transformer. The conventional transformer can thus be eliminated. This concept generally requires the slots in which the cables are placed in the stator to be deeper

than with conventional technology (thicker insulation due to higher voltage and more turns in the winding). This entails new problems with regard to cooling, vibrations and natural frequencies in the region of the coil end, teeth and winding.

5

The object of the invention is to provide a stator in a rotating electric machine with an end plate for use in direct cooling of the stator, particularly the stator teeth in a rotating electric machine of the type described, said cooling
10 being achieved by means of cooling tubes running axially in the stator. The purpose of the stator plate is to provide protection for the cooling tubes at the ends of the stator. The cooling tubes are exposed to mechanical stress at each end of the stator during assembly, which is eliminated
15 through the present invention.

Another object of the invention is for the stator plate to constitute a bending template for the cooling tubes during assembly. Additional advantageous further developments of the
20 invention are indicated in the following description. The invention is in the first place intended to be used with a high-voltage cable defined in more detail below, and its advantages are particularly noticeable therewith.

25 SUMMARY OF THE INVENTION:

The present invention relates to a stator end plate in connection with axial cooling of the stator and its laminated stack, particularly the stator teeth, and thus indirectly the stator winding in a rotating electric machine such as a high-
30 voltage alternating current generator.

The plate is provided with axially running winding slots corresponding to the stator, and axially running apertures for inlet and outlet cooling tubes. The plate is also provided
35 with slits in which bending members are situated, around which bending members the cooling tubes are arranged to be bent.

The end plate is also provided with assembly grooves intended to retain sealing member at the exit of each winding slot from the end plate.

5 In the device according to the invention the windings are preferably composed of cables having solid, extruded insulation, of a type now used for power distribution, such as XLPE-cables or cables with EPR-insulation. Such a cable comprises an inner conductor composed of one or more strand
10 parts, an inner semiconducting layer surrounding the conductor, a solid insulating layer surrounding this and an outer semiconducting layer surrounding the insulating layer. Such cables are flexible, which is an important property in this context since the technology for the device according to
15 the invention is based primarily on winding systems in which the winding is formed from cable which is bent during assembly. The flexibility of a XLPE-cable normally corresponds to a radius of curvature of approximately 20 cm for a cable 30 mm in diameter, and a radius of curvature of approximately
20 65 cm for a cable 80 mm in diameter. In the present application the term "flexible" is used to indicate that the winding is flexible down to a radius of curvature in the order of four times the cable diameter, preferably eight to twelve times the cable diameter.

25

The winding should be constructed to retain its properties even when it is bent and when it is subjected to thermal stress during operation. It is vital that the layers retain their adhesion to each other in this context. The material
30 properties of the layers are decisive here, particularly their elasticity and relative coefficients of thermal expansion. In a XLPE-cable, for instance, the insulating layer consists of cross-linked, low-density polyethylene, and the semiconducting layers consist of polyethylene with soot and metal particles
35 mixed in. Changes in volume as a result of temperature fluctuations are completely absorbed as changes in radius in the cable and, thanks to the comparatively slight difference

between the coefficients of thermal expansion in the layers in relation to the elasticity of these materials, the radial expansion can take place without the adhesion between the layers being lost.

5

The material combinations stated above should be considered only as examples. Other combinations fulfilling the conditions specified and also the condition of being semiconducting, i.e. having resistivity within the range of 10^{-1} - 10^6 ohm-cm, e.g.

10 1-500 ohm-cm, or 10-200 ohm-cm, naturally also fall within the scope of the invention.

The insulating layer may consist, for example, of a solid thermoplastic material such as low-density polyethylene
15 (LDPE), high-density polyethylene (HDPE), polypropylene (PP), polybutylene (PB), polymethyl pentene (PMP), cross-linked materials such as cross-linked polyethylene (XLPE), or rubber such as ethylene propylene rubber (EPR) or silicon rubber.

20 The inner and outer semiconducting layers may be of the same basic material but with particles of conducting material such as soot or metal powder mixed in.

The mechanical properties of these materials, particularly
25 their coefficients of thermal expansion, are affected relatively little by whether soot or metal powder is mixed in or not - at least in the proportions required to achieve the conductivity necessary according to the invention. The insulating layer and the semiconducting layers thus have
30 substantially the same coefficients of thermal expansion.

Ethylene-vinyl-acetate copolymers/nitrile rubber, butyl graft polyethylene, ethylene-butyl-acrylate-copolymers and ethylene-ethyl-acrylate copolymers may also constitute suitable
35 polymers for the semiconducting layers.

Even when different types of material are used as base in the various layers, it is desirable for their coefficients of thermal expansion to be substantially the same. This is the case with combination of the materials listed above.

5

The materials listed above have relatively good elasticity, with an E-modulus of $E < 500$ MPa, preferably < 200 MPa. The elasticity is sufficient for any minor differences between the coefficients of thermal expansion for the materials in the layers to be absorbed in the radial direction of the elasticity so that no cracks appear, or any other damage, and so that the layers are not released from each other. The material in the layers is elastic, and the adhesion between the layers is at least of the same magnitude as the weakest of the materials.

15

The conductivity of the two semiconducting layers is sufficient to substantially equalize the potential along each layer. The conductivity of the outer semiconducting layer is sufficiently large to enclose the electrical field in the cable, but sufficiently small not to give rise to significant losses due to currents induced in the longitudinal direction of the layer.

20

Thus, each of the two semiconducting layers essentially constitutes one equipotential surface, and these layers will substantially enclose the electrical field between them.

25

There is, of course, nothing to prevent one or more additional semiconducting layers being arranged in the insulating layer.

30

BRIEF DESCRIPTION OF THE DRAWINGS:

The invention will now be described in more detail with reference to the accompanying drawings.

35

Figure 1 shows a perspective view of an upper end plate according to the invention, in a rotating electric machine with vertical axis of rotation,

Figure 2a shows a perspective view of a lower end plate according to the invention, in a rotating electric machine with vertical axis of rotation,

Figure 2b shows a casting device according to the present invention,

Figure 2c shows a section through a high-voltage cable used in conjunction with the present invention,

Figure 3 shows a radial side view of the upper end plate in Figure 1,

Figure 4 shows a radial top view of the end plate in Figure 3,

Figure 5 shows an axial section A-A through the plate, taken as shown in Figure 4,

Figure 6 shows a radial section B-B through the plate, taken as shown in Figure 4,

Figure 7 shows a radial side view of the lower end plate in Figure 2,

Figure 8 shows a radial top view of the end plate in Figure 7,

Figure 9 shows an axial section C-C through the plate, taken as shown in Figure 8,

Figure 10 shows a radial section D-D through the plate, taken as shown in Figure 8,

Figure 11 shows a how the cooling tubes are drawn through the upper end plate, fitted at the upper end of the stator, and

Figure 12 shows a cooling circuit in conjunction with the present invention.

DESCRIPTION OF THE INVENTION:

Figure 1 shows an upper stator end plate 1 provided with 10-12 axially running winding slots 2 corresponding to a stator, arranged radially, the number depending on the design of the stator, said winding slots forming a radial chain slot 3. The

stator end plate is also provided with an inlet slit 4 and an outlet slit 5 for cooling tubes with flows to and from the laminated stack. The stator end plate 1 is in the form of a circle sector with one, two or more chain slots. The sectors are assembled side by side to form a whole circular plate covering one end of the stator (the upper end if the axis of the machine is vertical). The plate 1 is also provided with two upper casting channels 6, 7 arranged radially in the chain slot 3 in order to embed an upper sealing member 8 at the exit of each winding slot 2 from the plate 1 (only one sealing member is shown in Figure 1). Figure 1 also shows a transverse slit 9 for cooling tubes running in the stator yoke. A recess 10 is also provided for the fixing bar of the "core".

Figure 2a shows a lower stator end plate 11 which, in equivalent manner to the upper stator end plate in Figure 1, is provided with the same number of axially running winding slots 2 corresponding to the stator as in the upper plate (10-12), arranged radially and in equivalent manner forming a radial chain slot 3. The lower stator end plate 11 is provided with one or more turn-around slits 12 in which cooling tubes are arranged to run out of the laminated stack, turn and run into it again. As described for the upper plate, the lower stator end plate 11 is designed as a circle sector with one, two or more chain slots. The sectors are assembled side by side to form a whole circular plate covering one end of the stator (in this case the lower end if the axis of the machine is vertical). The stator end plate 11 is also provided with two lower casting channels 13, 14 arranged radially in the chain slot 3 in order to embed a lower sealing member 15 at the exit of each winding slot 2 from the plate 1 (only one sealing member is shown in this Figure as well). As can be seen in the Figures, these sealing members may be shaped differently depending on which plate they belong to. They may also protrude different lengths from the plate depending on the protection each member is to provide. The lower stator end plate 11 is also provided with a recess 10 for the fixing bar

of the "core". Figure 2 also shows that the lower stator end plate 11 is provided with a number of attachment holes 16 for a casting device 100, see Figure 2b, and assembly holes 17 for a locking bolt that locks the plate 11 to a lower thick metal sheet constituting an annular part of the stator frame.

Figure 2b shows the casting device 100 provided with nipples 110 in the region of the turn-around slits 12. The casting device 100 is arranged to be connected to the lower stator end plate 11 by attachment bolts 120. The casting device 100 is also provided with rubber seals 125 against the end plate, at silicon embedment of the cooling tubes.

The procedure for embedding the sealing members is for detachable tools in the form of cylindrical plugs for casting the members to be fitted on the end plate and casting compound injected into a casting inlet in the plate, the compounding then spreading to all the cable positions.

The procedure for casting cooling tubes is that the casting device is sealingly connected to a first laminar plate and silicon is then forced in around the cooling tubes until the silicon "runs out" at the upper end plate. The casting device is then removed and attached to another laminar plate and the injection procedure is repeated, and so on until all cooling tubes have been embedded in silicon. The cooling tubes are thus embedded both inside the end plates and inside the stator. Furthermore, the casting device can be used again.

Two separate casting processes are thus used, one for sealing members and the other for cooling tubes. Different types of silicon are often used for these processes.

Figure 2c shows a cross section through a high-voltage cable 111 for use in connection with the present invention. The high-voltage cable 111 is composed of a number of strand parts 112 made of copper (Cu), for instance, and having circular

cross section. These strand parts 112 are arranged in the middle of the high-voltage cable 111. Around the strand parts 112 is a first semiconducting layer 113. Around the first semiconducting layer 113 is an insulating layer 114, e.g. XLPE-insulation, and around the insulating layer 114 is a second semiconducting layer 115. The concept "high-voltage cable" in the present application thus does not include the outer sheath that normally surrounds such a cable for power distribution. The high-voltage cable has a diameter within the interval 20-250 mm and a conducting area within the interval 40-3000 mm².

Figure 3 shows both casting channels 6, 7 of the upper stator end plate 1, and a casting inlet 18 for injecting the casting compound.

Figure 4 shows the upper stator end plate 1 from above, with an inlet aperture 19 for a cooling tube in the inlet slit 4, and a first bending member 20 for this cooling tube. Cooling tube apertures for returning cooling tubes are also shown, with turning members 23 between them. As indicated in the Figure, the outlet slit 5 is arranged in corresponding manner, i.e. with an outlet aperture 24 and corresponding first and second bending members 20, 23. The inlet and outlet slits 4, 5 are also provided with turned cavities 25 of thicker diameter on the yoke side of the stator, to enable connection of the cooling tube to a thicker tube for extra protection.

In an axial section through the plate, Figure 5 shows a winding slot 2 and the upper casting channels 6, 7.

In a radial section through the plate, Figure 6 shows the inlet slit 4 which extends from the inlet aperture 19 to the turned cavity 25. It can be seen from this Figure that the first bending member 20 is higher than the second bending member 23 so that the cooling tube acting as inlet to the stator is closer to the surface than the cooling tube that

returns in this plate, i.e. the cooling tubes are situated one above the other in the inlet slit 4.

For the upper stator end plate 1 the plate thickness t_u , is
5 such that $t_u \geq 2F_r$, where F_r is the external diameter of the cooling tube so that all cooling tubes are covered by the plate.

Figure 7 shows the two casting channels 13, 14 of the lower
10 stator end plate 11, and a casting inlet 18 for injection of casting compound. What differentiates the lower plate from the upper plate is that the plate thickness t_l is less and that the casting channels 13, 14 are closer together.

15 Figure 8 shows the lower stator end plate 11 from its outer side, revealing its turn-around slits 12, the cooling-tube apertures 19, 21, 22 and a cooling-tube aperture 26 located in the stator yoke. All these cooling-tube apertures 19, 21, 22, 26 constitute openings in this plate for returning cooling
20 tubes with third bending members 27 between them.

In an axial section through the plate in Figure 8, Figure 9 shows a winding slot 2 and the lower casting channels 13, 14. The section also reveals that the lower plate is provided with
25 an opening 28 for the casting device.

Figure 10 shows a radial section through the lower stator end plate 11 and through a lower, thick metal sheet 30 connected to the plate by a locking bolt 29. The three bending members
30 27 are also shown recessed in the turn-around slits 12, as well as the attachment holes for the casting device. The lower plate is thus designed for cooling tubes that return inside the plate. Since no inlets or outlets are arranged in the lower plate, the thickness of this plate can be kept to a
35 minimum. For the stator end plate 11, therefore, the plate thickness t_l is such that $t_l \geq F_r$, where F_r is the outer

diameter of the cooling tube, so that all cooling tubes are covered by the plate.

Figure 11 shows a section through a part of a stator 31 provided with cooling tubes, with its stator core 32, at one end of which the stator end plate 1 is fitted. It is clear from the Figure that all the cooling tubes 33 running in the inlet and outlet slits are recessed in the stator end plate 1 so that they are protected from mechanical stress. The cooling tubes 33 are also connected to an inlet circuit 132 for inlet medium and an outlet circuit 133 for outlet medium.

Figure 12 shows that all cooling tubes are connected to a closed cooling circuit 129 which, in the embodiment shown, comprises a tank 30 containing the coolant 131 which may be water, hydrogen or other coolant. The tank 130 is provided with a level indicator for controlling and monitoring the level of the coolant. The tank 130 is also connected to two annular tubes consisting of the inlet circuit 132 and outlet circuit 133. Between the inlet circuit 132 and the outlet circuit 133 a number parallel circuits is connected, the number often corresponding to the number of stator teeth or tooth sides provided with cooling tubes. One of these parallel circuits 134 is shown in Figure 12. The coolant 131 is arranged to circulate from the inlet circuit 132, simultaneously through all the parallel circuits 134, to the outlet circuit 133 and on to a circulation pump 135, to a circulation filter 136 through a heat-exchanger 137, e.g. a plate heat-exchanger, and then back to the inlet circuit 132. Water from a water supply is fed by an exchanger pump 138 through one end of the heat-exchanger 137 via a filter, not shown. The water is pumped through the exchanger and back to the water supply.

The stator end plates described are preferably made from laminated material. They may be in the form of a completely circular plate instead of being divided into sectors as

described above. Furthermore, all cooling tubes are embedded in silicon rubber in the stator, in order to improve the heat transfer between the laminated stack and cooling tubes.

- 5 The stator end plate, either upper or lower, has an axial thickness t such that $t \geq F_r$, where F_r is the outer diameter of the cooling tube. The designation t may here represent either t_1 or t_u .
- 10 The second and third bending members 23, 27 of the stator end plates are bent in one or two steps, each step constituting an angle of 90° as shown in Figures 6 and 10, or in one step with an angle of 180° , i.e. as a semi-circle, if the distance between the cooling tubes corresponds to the diameter of the
- 15 bending circle. The first bending member 20 at the inlet aperture and outlet aperture is bent in one step at an angle of 90° . The bending members 20, 23, 27 are thus bent in one or two steps, each step constituting an angle of 90° .

CLAIMS

1. An end plate (1, 11), characterized in that the end plate (1, 11) is adapted to a stator (31) wound with cable in a rotating electric machine the plate (1, 11) is provided with axially running winding slots (2) corresponding to the stator (31) and axially running apertures (19, 21, 22, 26) for cooling tubes corresponding to the stator (31), and that the plate (1, 11) is provided with at least one bending member (20, 23, 27) pre-shaped in the plate (1, 11) for cooling tubes (33) insertable into the cooling-tube apertures (19, 21, 22, 26).
2. An end plate as claimed in claim 1, characterized in that the plate (1, 11) is radially divided into sectors, each sector corresponding to one or more slot divisions.
3. An end plate as claimed in any of claims 1-2, characterized in that the plate (1, 11) is produced from a laminated material.
4. An end plate as claimed in any of claims 1-3, characterized in that the plate (1, 22) has an axial thickness t such that $t \geq F_r$, where F_r is the external diameter of the cooling tube (33).
5. An end plate as claimed in any of claims 1-4, characterized in that the bending member (20, 23, 27) is bent in one or two steps, each step constituting an angle of 90° .
6. An end plate as claimed in claim 5, characterized in that the plate (1, 11) is provided with at least one inlet slit (5) for the outlet of the cooling tube.

7. An end plate as claimed in claim 5, characterized in that the plate (1, 11) is provided with a turn-around slit (12) in which a bending member (20, 23, 27) is situated.

5

8. An end plate as claimed in any of claims 1-7, characterized in that the end plate (1, 11) is provided with casting channels (6, 7, 13, 14) intended, together with a tool in the form of plugs, to embed a sealing member (8, 15), preferably of rubber, at the exit of each winding slot (2) from the plate (1, 11).

9. An end plate as claimed in any of claims 6-8, characterized in that the plate (1, 11) is provided with attachment holes (16) for insertion of a casting device (100) prior to casting.

10. An end plate as claimed in claim 9, characterized in that the casting device (100) is shaped to seal at least one of the turn-around slits (12) of the plate (1, 11) and is provided with a nipple (110) for pressing in the casting compound.

11. An end plate as claimed in any of the preceding claims, characterized in that the stator (31) is wound with high-voltage cable (111).

12. An end plate as claimed in any of the preceding claims, characterized in that the plate is dimensioned for a high-voltage cable (111) having a diameter within the interval 20-250 mm and a conducting area within the interval 40-3000 mm².

13. A procedure for supporting and protecting a cooling tube in a first axially running aperture at its exit from a stator in a rotating electric machine, characterized in that an end plate provided with bending members is applied

at the end of the stator, the cooling tube being bent around the bending member before continuing, either by being fitted in a second axially running aperture in the stator or for extension out of the stator.

5

14. An end plate as claimed in any of claims 1-12, characterized in that the winding is flexible and comprises an electrically conducting core surrounded by an inner semiconducting layer (113), an insulating layer (114) surrounding the inner semiconducting layer (113) and consisting of solid material, and an outer semiconducting layer (115) surrounding the insulating layer, said layers (113, 114, 115) being adhered to each other.

15

15. An end plate as claimed in claim 14, characterized in that said layers (113, 114, 115) consist of material having such elasticity and with such a relation between the coefficients of thermal expansion of the materials that the changes in volume in the layers (113, 114, 115) caused by temperature fluctuations during operation can be absorbed by the elasticity of the material, the layers (113, 114, 115) thus retaining their adhesion to each other upon the temperature fluctuations that occur during operation.

25

16. An end plate as claimed in any of claims 14-15, characterized in that the material in said layers (113, 114, 115) has high elasticity, preferably an E-modulus less than 500 MPa, most preferably less than 200 MPa.

30

17. An end plate as claimed in any of claims 14-16, characterized in that the coefficients of thermal expansion for the materials in said layers (113, 114, 115) are substantially the same.

35

18. An end plate as claimed in any of claims 14-17, characterized in that the adhesion between layers

(113, 114, 115) is of at least the same magnitude as in the weakest of the materials.

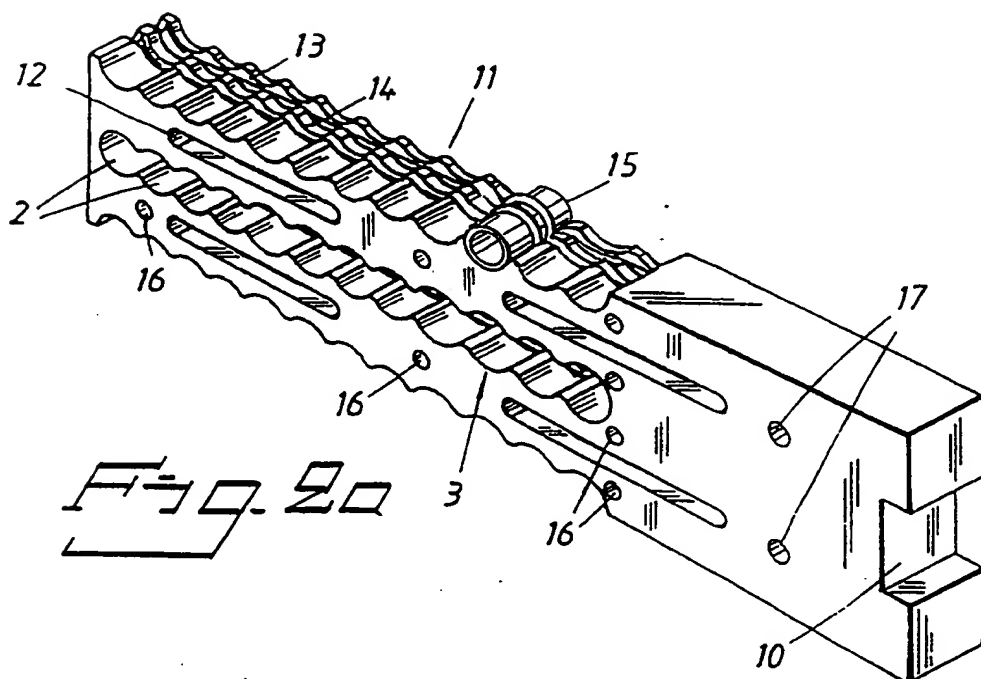
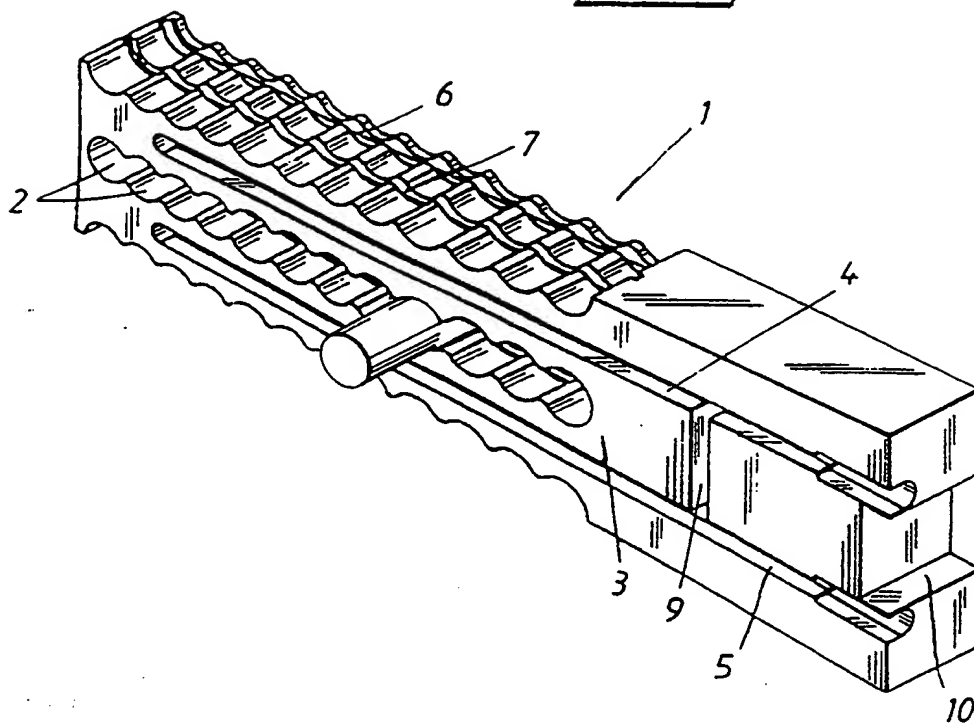
19. An end plate as claimed in any of claims 14-18,
5 characterized in that each of the semiconducting
layers (113, 115) essentially constitutes one equipotential
surface.

20. A rotating electric machine, characterized in
10 that it is comprising an end plate (1, 11) according to any
of the claims 1-12 or 14-19.

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Fig. 1



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Fig. 26

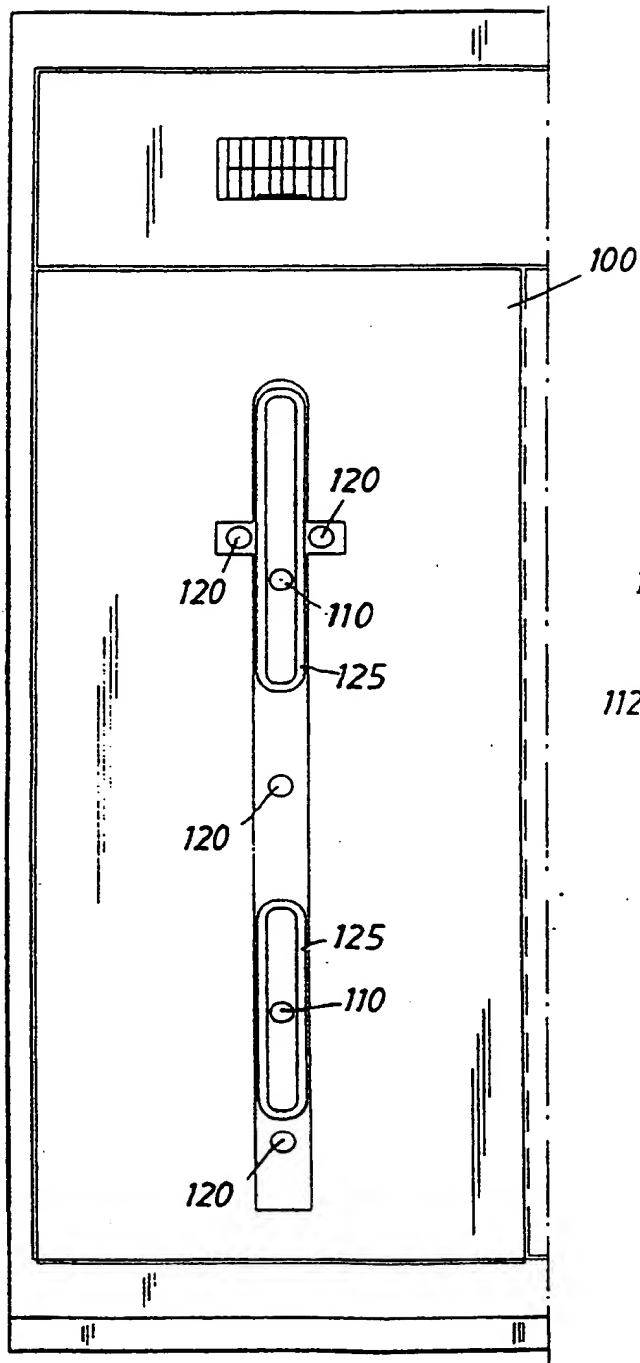
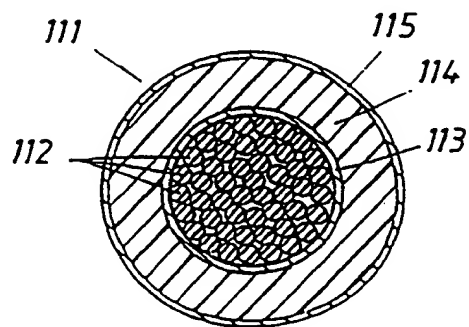


Fig. 2c



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Fig. 3

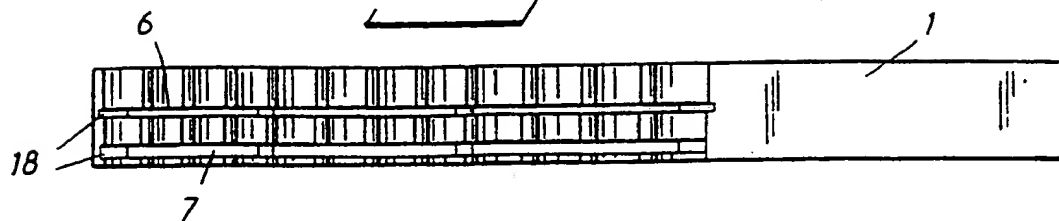


Fig. 4

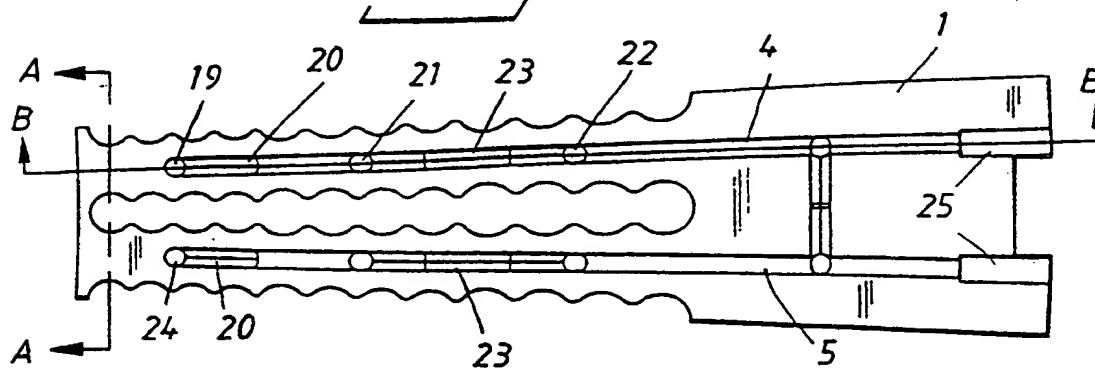


Fig. 5

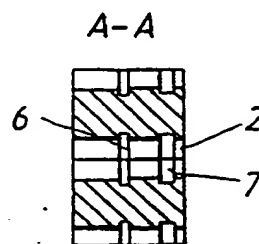
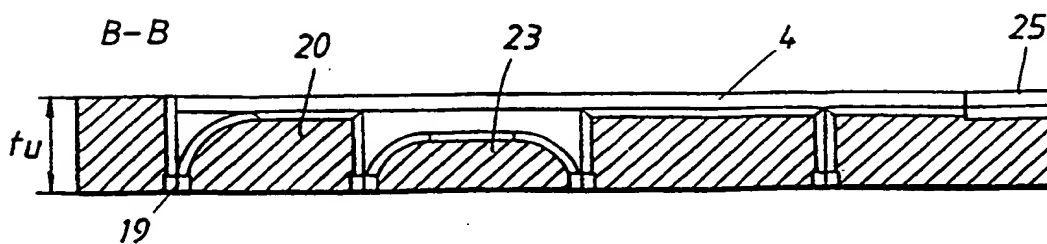


Fig. 6



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Fig. 7

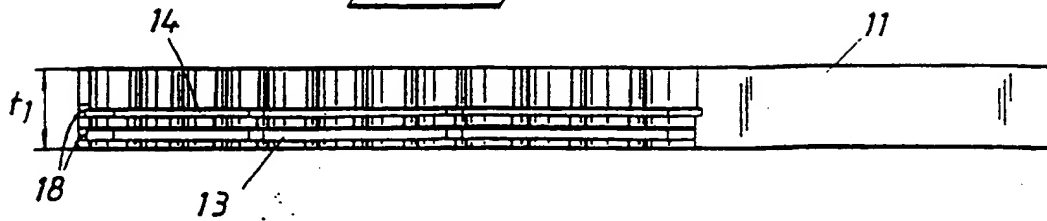


Fig. 8

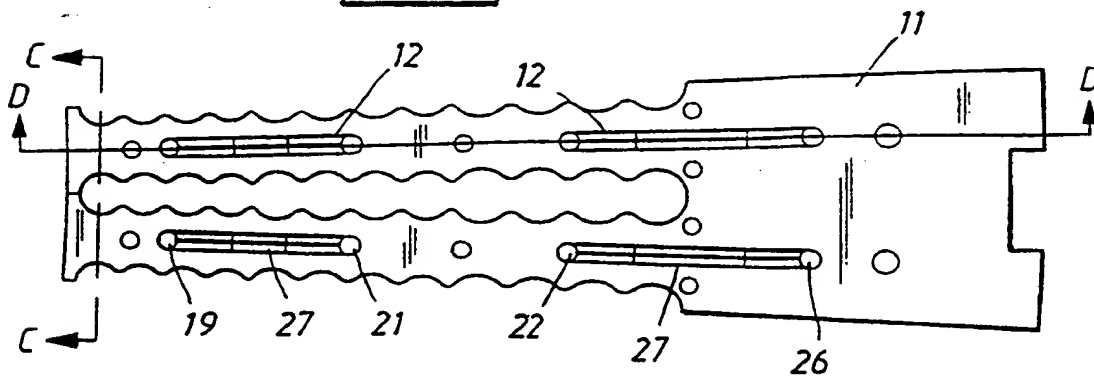


Fig. 9

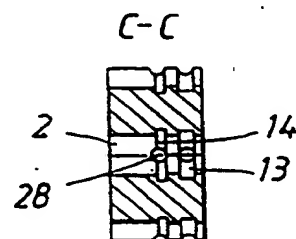
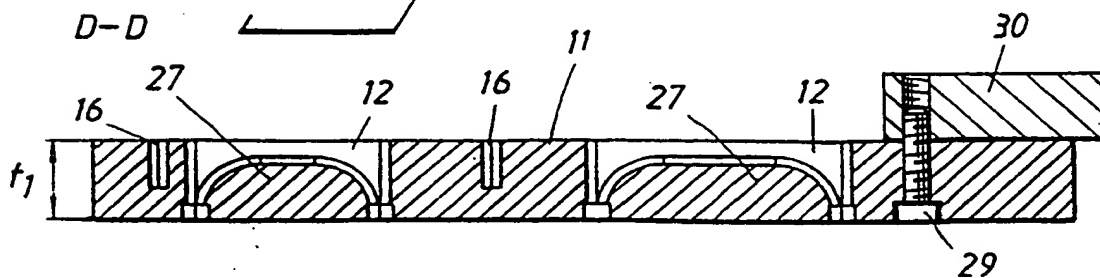


Fig. 10



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Fig. 11

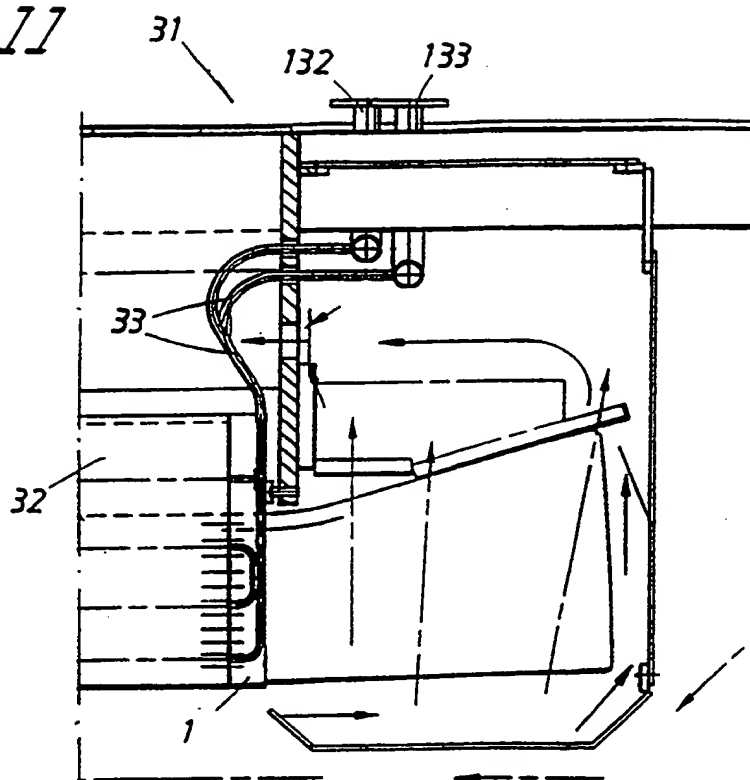
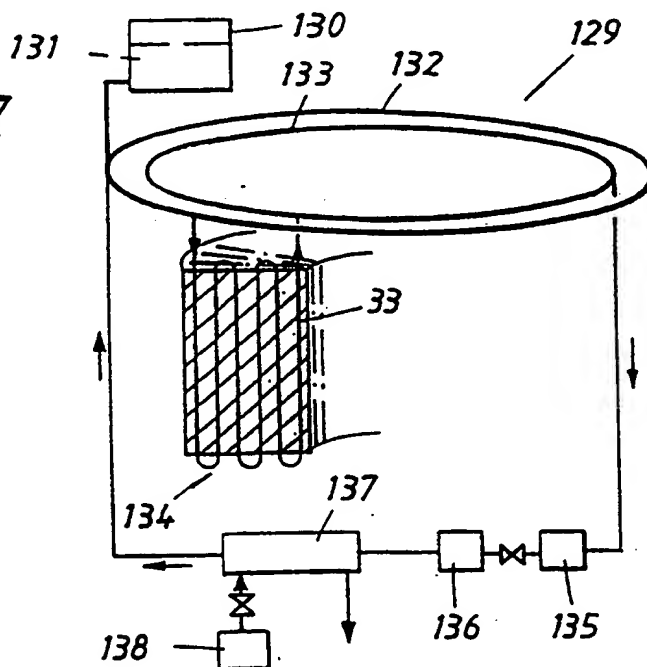


Fig. 12



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INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE 98/00163

A. CLASSIFICATION OF SUBJECT MATTER

IPC6: H02K 1/20

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC6: H02K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

WPI

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 3435262 A (R.B.BENNET ET AL), 25 March 1969 (25.03.69), figures 1-5, abstract	1-20
	--	
A	US 3447002 A (C.RÖNNEVIG), 27 May 1969 (27.05.69), figures 1-4, abstract	1-20
	--	
A	GB 2289992 A (GEC ALSTHOM LIMITED), 6 December 1995 (06.12.95), figures 1-13, abstract	1-20
	--	
A	US 4152615 A (R.M.CALFO ET AL), 1 May 1979 (01.05.79), figures 1-4, abstract	1-20
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Further documents are listed in the continuation of Box C.



See patent family annex.

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Date of the actual completion of the international search

15 July 1998

Date of mailing of the international search report

17 JUL 1998

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International application No.

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C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5036165 A (R.K. ELTON ET AL), 30 July 1991 (30.07.91), figure 1, abstract --	1,14-20
A	US 4853565 A (R.K.ELTON ET AL), 1 August 1989 (01.08.89), figure 7, abstract -- -----	1,14-20

INTERNATIONAL SEARCH REPORT

Information on patent family members

30/06/98

International application No.

PCT/SE 98/00163

Patent document cited in search report			Publication date	Patent family member(s)	Publication date
US	3435262	A	25/03/69	NONE	
US	3447002	A	27/05/69	CH 450535 A DE 1513734 A FR 1471083 A GB 1132997 A SE 318939 B	30/04/68 18/06/70 22/05/67 06/11/68 22/12/69
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